

✓ Page 3, line 25 insert:

--SUMMARY OF THE INVENTION--;

✓ Page 17, line 8, insert:

--BRIEF DESCRIPTION OF THE DRAWINGS

✓ Page 18, line 9, insert:

DETAILED DESCRIPTION OF THE INVENTION--.

IN THE CLAIMS:

Please amend the claims as follows:

01.A lathing process for non-circular cutting on programmable lathing machines whereby a workpiece is rotated in the chuck of a machine spindle and using a traversable tool at least partial specific non-circular, discontinuous or abruptly changing contours are cut, characterised in that the turning takes place in jerks, in that the tool is synchronised to the spindle angle and the described contour comprising rounded geometrical transition elements or compound contours is generated by a program comprising jump functions created by linking command blocks with values for selected address parameters such as diameter (X), length (Z), height (Y) and pitch (F) or angle (C), whereby for at least one of these address parameters the program block chain employs a jerk, i.e. a sequence of address parameter values which build into a jump function.